

Work Order ID 69661

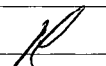


Monday, May 16, 2011 9:17:08 AM



Page 1


Item ID: D3414-041 Accept  Setup Start 
Revision ID:
Item Name: Lug Assembly Stop 
Start Date: 5/16/2011 Start Qty: 12.00  Cust Item ID:
Required Date: 5/31/2011 Req'd Qty: 12.00  Customer:

Reference:

Approvals: Process Plan:  Date: 11-05-16 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3414	Rev C								

100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3414-1								
304.100	Dwg Rev: <u>E</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								

AB11-5-16

Pto →




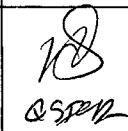

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

AB11-5-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3414-041 PAR #: N/A Fault Category: (Water Jet) Small Frag NCR: Yes No DQA: A Date: 11.06.20
 11-678 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/09/21

NCR: 62661		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/16	# 100	Found AM +1 Part with A cut out in one of the tabs. near a hole. Re. water jet marks when it still had pieces in the line. Machine malfunction D3414-1 is scrap not -041		- Scrap + Destroy no Re/Proc extra was made.	 11-5-16	 11/05/16		 11/05/16






NOTE: Date & initial all entries



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SB 11/6/16		(X12)	11		
130  Brake NC Brake NC	Memo 1-Debur 2-Form using DT8254 as per Dwg D3414	0.00 0.00		SB 11/6/17		(12)			
140  Large Fab Large Fab	Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: M107051	0.00 0.00				A	11-6-15	(X12)	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									

CP 11-06-15

160	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

8 w/06/16

(42)

175		0.00							
									
SprayPaint									
Spray Painting	Memo	0.00							
	PRIME B <i>117319</i>								
	SPRAY PAINT DELFLEET BLUE B <i>115985</i>								
	CLEAR DELFLEET B <i>117984</i>								

85 11-06-16 (x18)

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185  QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				<u>11</u>	<u>06</u>	<u>17</u>	
190  Packaging Packaging	Identify as per dwg & Stock Location: <u>Q20</u> Memo	0.00 0.00							
200  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Ref 17 (12)

11/6/2011
MF
(1-06-17)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, May 16, 2011 9:17:15 AM





[illegible]

(b) (7)(C), (b) (7)(D)

Required Date: 5/31/2011

Required Qty: 12.00

Comments: IPP A05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA  304/316 0.100" Sheet		Purchased	No			100	sf	152.3000	0.155	1.86			
												B11-5-16	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			(B)
					MAT019			152.3				113062	
					113062			120.3					
					113077			32					
D3414-3  Lug		Manufactured	No			140	Each	2.0000	1	12			
												E2 11-6-14	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA030			2				2	
					66944			2					
					09882			10				10	

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>4661</i>
Description: Lug Bracket		Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	<i>0.313</i>	<i>✓</i>		<i>V 1302</i>	
1.19	+/-0.030	<i>1.182</i>	<i>✓</i>		<i>V</i>	
1.00	+/-0.030	<i>1.010</i>	<i>✓</i>		<i>V</i>	
3.38	+/-0.030	<i>3.383</i>	<i>✓</i>		<i>V</i>	
5.350	+/-0.010	<i>5.355</i>	<i>✓</i>		<i>V</i>	
6.23	+/-0.030	<i>6.231</i>	<i>✓</i>		<i>V</i>	
2.500	+/-0.010	<i>2.502</i>	<i>✓</i>		<i>V</i>	
0.37	+/-0.030	<i>0.368</i>	<i>✓</i>		<i>V</i>	
0.100	+/-0.010	<i>0.105</i>	<i>✓</i>		<i>V</i>	

Measured by: <i>B</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>11-5-16</i>	Date: <i>11/05/16</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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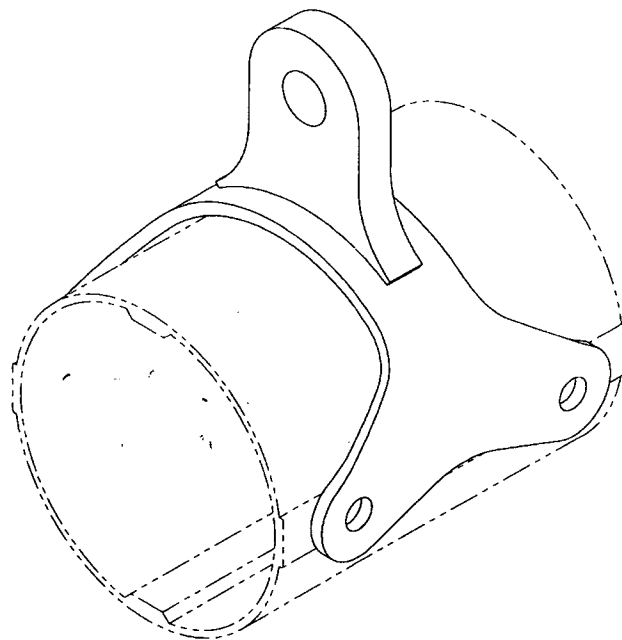
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NOTE: Date & initial all entries

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69661

11-05-14

RELEASED
01/16/05/04

C	BREAK SHARP EDGES FOR -.3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

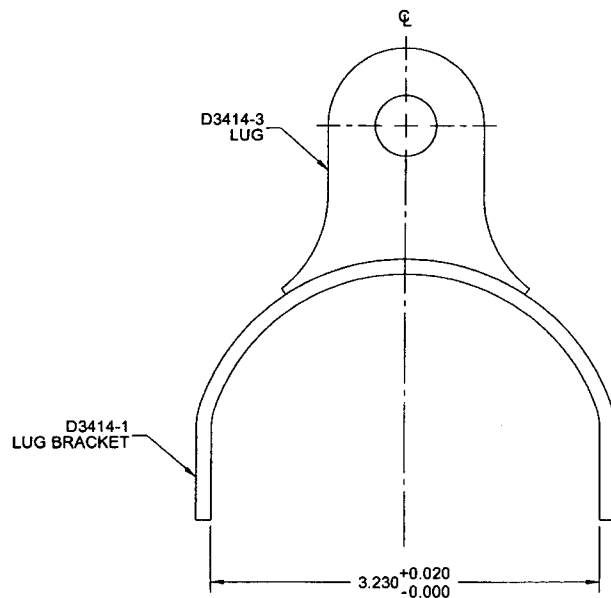
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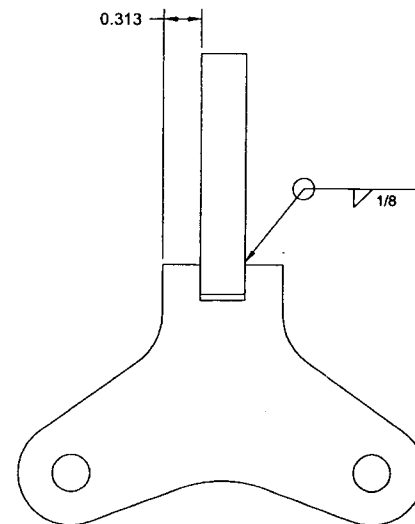
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3414-041 LUG ASSEMBLY



u1069661

RELEASED
09/06/17

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3414	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	LUG ASSEMBLY	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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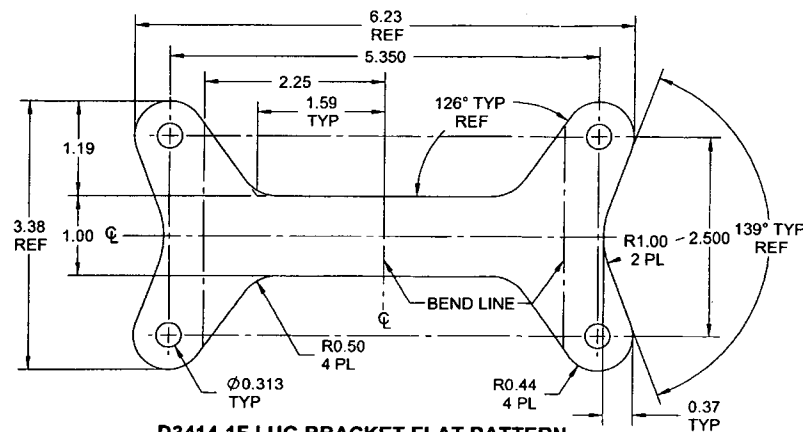
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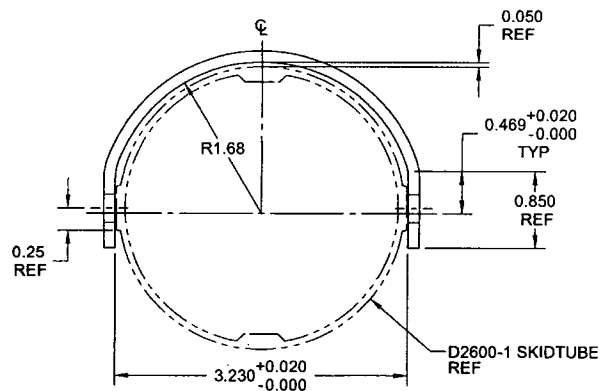
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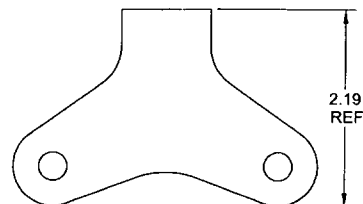
NOTE: Date & initial all entries



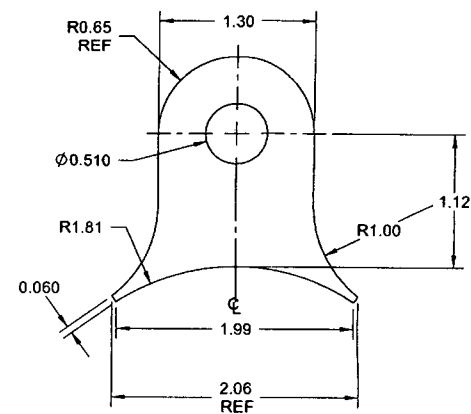
D3414-1F LUG BRACKET FLAT PATTERN



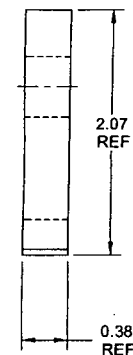
D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG



NOTES:
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX \triangle
-3: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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RELEASED
29/10/2016

u/o. 10/10/16

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